

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012043**Date Inspected:** 16-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	An Qing Xiang, Wang Chuan Qin			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Tower		

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10 SOUTH TOWER LIFT 2 CABLE HOLES ON SKIN A

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

SSD1-SA164A/F-11, 35 GREEN TAG NO. 11592

BAY 10 STRUT ANGLE CONNECTION PLATE

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

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ND1-A5002-1~18-1A/B GREEN TAG NO. 11708

BAY 10 SOUTH TOWER LIFT 2 HANDRAILS ON SKIN A & E

This QA Inspector issued the green tag for the following components

E76-53M-5, 6-S GREEN TAG NO. 11590

E74-65M-1, 2, 3-S GREEN TAG NO. 11590

E74-77M-1, 2, 3-S GREEN TAG NO. 11590

E74-65M-5, 6, 7-S GREEN TAG NO. 11590

E74-77M-5, 6, 7-S GREEN TAG NO. 11590

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 11

STRUT ANGLE CONNECTION PLATE

SMAW welding of weld joint 1A located on ED1-SA4-68-123M-7.

Welder is identified as 040656. ZPMC QC is identified as Mr. Mao Bin Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

TOWER STRUT

SAW welding of weld joint 7A located on ND1-STSA4-6-135M-2.

Welder is identified as 040699. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

EAST TOWER LIFT 5 D/E CORNER SEAM

SMAW welding of weld joint 40A located on ESD1-TL5-2B/F.

Welder is identified as 040655. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U4b-1.

EAST TOWER LIFT 5 C/D CORNER SEAM

SMAW welding of weld joint 39A located on ESD1-TL5-2B/F.

Welder is identified as 040667. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U4b-1.

EAST TOWER LIFT 5 A/B CORNER SEAM

SAW welding of weld joint 37A located on ESD1-TL5-2B/F.

Welder is identified as 042195. ZPMC QC is identified as Mr. Xu Jin Long.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-C-U2b-S.

BAY 10

NORTH TOWER LIFT 4 D/E CORNER SEAM REPAIR

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SMAW welding of weld joint 2A/B (Repair) located on NSTL4-3B/L.

Welder is identified as 052930. ZPMC QC is identified as Mr. Jiang Xiao Bo.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G(1F)-REPAIR.

SOUTH TOWER LIFT 4 D/E CORNER SEAM REPAIR

SMAW welding of weld joint 2A/B (Repair) located on SSTL4-1B/L.

Welder is identified as 052289. ZPMC QC is identified as Mr. Wang Hao.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G(1F)-REPAIR.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
